



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA10A-300
Job Sheet 197247



Part No: SWA10A-300

Job Qty: 6 pcs

Part Name: Bearing Housing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 8/30/19

Description:

Type: Stock

Note: DWG SWA10A-300 Rev 5 IPP Rev A 17.12.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
190	Bandsaw - 1	6 pcs	8/30/19	8/30/19	0.00 0.60	Bandsaw - 1	
110	NLX 2500SY - B4B	6 pcs	8/30/19	8/30/19	1.00 6.00	NLX 2500SY - 1 - B4B	
120	QC 2	6 pcs	8/30/19	8/30/19	0.00 0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 6	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
130	QC 8	6 pcs	8/30/19	8/30/19	0.00 0.00	QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	



Container No: S227495



Part: SWA10A-300

Job No: 197247

Serial No/Batch: S227495

Revision: 5

Inspector:

Exp Date:

Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 10/29/19

7/3/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Packaging 3-1 - Stock - B4B 6 pcs	8/30/19	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	6 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut Blanks to 3.560" Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG. FB711 FOLIO REV: AA DWG REV: ' 2-Debur 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location:) 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H1150-R4.000	17-4 SS H1150 Round Bar 4.000"	1,8000 ft (.3 ea)	100-Bandsaw - 1	S202401	

4-H1150-R4.000
S202401

Plex 7/3/19 12:46 PM Dart.Renwick.Jennifer

7/3/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-H1150-R4.000	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 7/3/19 12:46 PM Dart.Renwick.Jennifer

DART AEROSPACE LTD		Work Order:
Description: Bearing Housing		Part Number: SWA104-300
Inspection Dwg: SWA104-300	Rev:	Page 1 of 1

INSPECTION SHEET

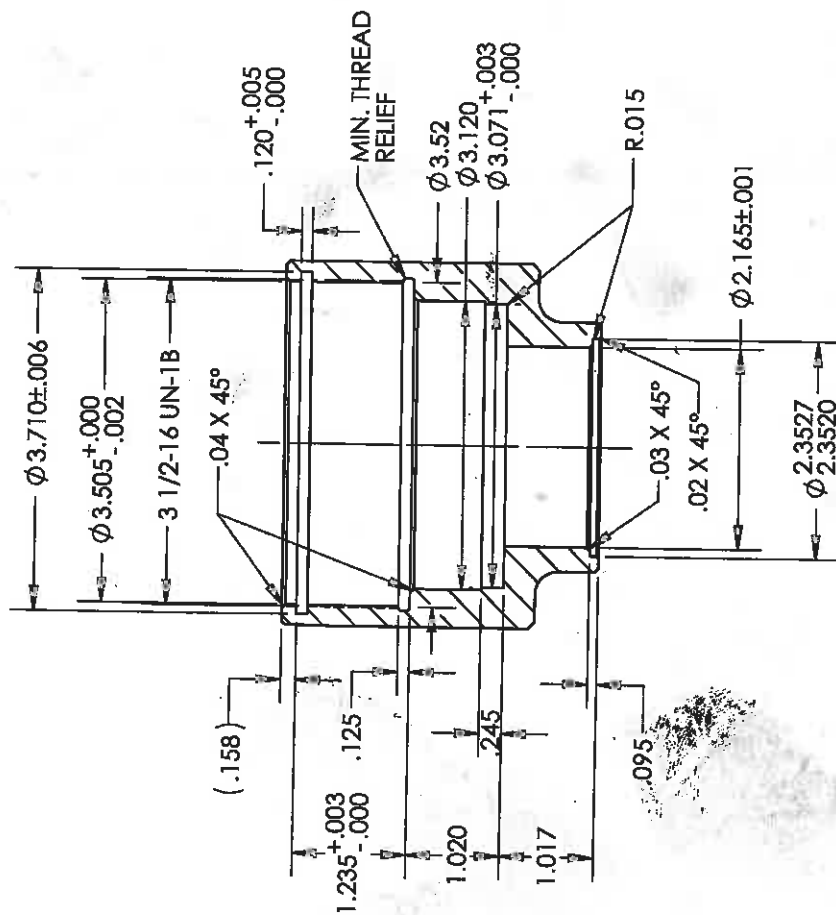
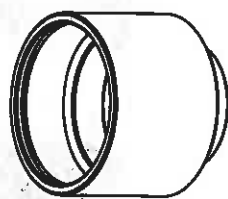
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.710	±.006	3.712			112-177	
Ø 3.505	+0.00/-0.02	3.505			Mic JBOS	
3 1/2 -16 UN 1B	GO/NOGO	GO			GO/NOGO	
.04 x 45°	±.01 x .5°	.04 x 45°			Vern P10	
1.235	±.003/-0.00	1.236			H-gauge	
1.020	±.005	1.018			↓	
.245	±.005	.243			Vern L P10	
1.017	±.005	1.021			H-gauge	
.095	±.005	.090			↓	
.03 x 45°	±.01 x .5°	.03 x 45°			Vern L P10	
.02 x 45°	±.01 x .5°	.02 x 45°			↓	
Ø 2.165	±.001	2.165			Mic L P10	
Ø 2.3520/2.3521		2.3527			GO/NOGO	
Ø 3.071	+0.00/-0.002	3.073			Mic JBOS	
Ø 3.120	±.005	3.1205			↓	
Ø 3.52	±.01	3.522			Mic 112-177	
.120	±.005/-0.00	.122			Gauge An	
Ø 3.950	±.005	3.950			JBOS JBOS	
3.430	±.005	3.430			H-gauge	
.680	±.005	.675			↓	
Ø 2.70	±.01	2.700			Vern L P10	
.04 x 45°	±.01 x .5°	.04 x 45°			↓	
.07 x 45°	±.01 x .5°	.065 x 45°			↓	
.25	±.01	.25			Rad gauge	

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 14-10-30	Date: 19/01/08	Date:

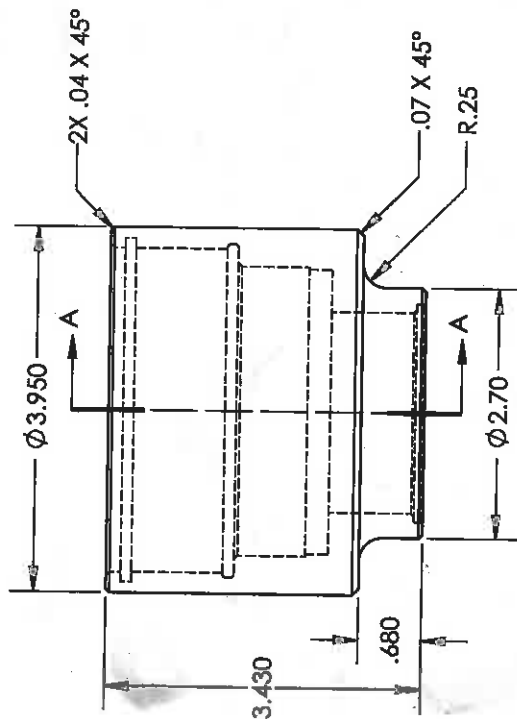
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	11/12/2012	JAG	
3		CHTD TOLERANCE OF Ø2.352+-.003/--.000 TO A LIMIT DIM.	11/16/2012	JAG	
4	15-0304	UPDATED TO NEW DRAFTING STANDARDS. ADDED MAT'L OPTION H1075.	10/16/2015	DPD	JAG
5	16-0252	CHTD THREAD DIM WAS 3-1/2-1.6 UN -2B IS 3-1/2-1.6 UN -1B. ADDED MIN. THREAD RELIEF NOTE.	12/5/2014	PIC	JAG



SECTION A-A



BEARING HOUSING

DWG NO.	SWA10A-300			REV	5
MAT'L SS 17-4 H1160/H1075		UNLESS OTHERWISE SPECIFIED			
HEAT TREAT		DIMENSIONS ARE IN INCHES			
FINISH		FRACTIONS 3/16			
SPEC		XXX ± .005			
		XX ± .01			
		X ± .1			
		SURFACES = 125			
		1. BREAK ALL SHARP EDGES			
		.015 X 45° OR R1R			
		2. DIMENSIONAL LIMITS APPLY AFTER PLAYING			
		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2000			
DRAWN BY: CANAM		USED ON MODEL			
CHECKED: MACKOVJAK					
DPPS APPR: ANDERSON					
QA APPR: LINDSAY					
APPROVED: GILBERT					
SCALE	1:2	DATE	2/21/2002	SHEET 1 OF 1	

ASSY QTY		ASSY B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-300	1	BEARING HOUSING	SS 17-4 H1150/H1075	